Each

Dart Aerospace Ltd. Friday, 7/4/2008 12:48:44 PM Date: Kim Johnston User: **Process Sheet** : SADDLE SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 40282 : 11063 **Estimate Number** : D2935 Part Number P.O. Number D2935 REV B : 7/4/2008 S.O. No. : **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : SMALL /MED FAB : // **Drawing Revision** First Issue Type : 37867 Material Previous Run : 7/11/2008 Qty: 40 Um: **Due Date** Written By Checked & Approved By New Issue EC Comment Est Rev:B Now 6061-T6 06-06-23 JLM Additional Product Job Number: Description: Seq. #: M6061T6S080 6061-T6 .080 Sheet 1.0 Comment: Qty.: Total: 2.1294 sf(s) 0.0532 sf(s)/Unit Material: M6061-T6 0.080" Thick Batch 19295 08 07 08 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2935 m 08 07 08 Dwg Rev: ____ Prog Rev:__/ 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK 4.0 QC8

Comment: SECOND CHECK

HAND FINISHING1 HAND FINISHING RESOURCE #*

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4





5.0

Dart Aerospace Ltd

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Ŵ/O:		WORK ORDER CHANGES					1	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							!	
							ı	
Part No):	PAR #: Fault Category: NO	CR: Yes	s No DQ	A:	Date: _		
			QA:	N/C Close	:d:	Date: _	 ,	
.		WORK OPPED NON CONFORMANO	F /\\C	<u> </u>			i	

	\	WORK ORD	ER NON-CONFORMANC	E (NCR)			1
	TEP Section A Initial Action Des		Vanification				
STEP		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
						-	
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Portion Description Section B Verification Approval Chief Eng

NOTE: Date & initial all entries

Friday, 7/4/2008 12:48:44 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 40282 Part Number: D2935 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock

8.0 QC21 FINAL INSPECTIONW/O RECEA

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-07-17

Job Completion

Dart Ae	rospace L	_td								
W/O:			V	ORK ORDER CH	ANGES		<u> </u>			
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _	
						QA: N	C Close	d:	_ Date: _	4
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR)			•
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
			Ciller Eng	Chief Eng		Date				,
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40282
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

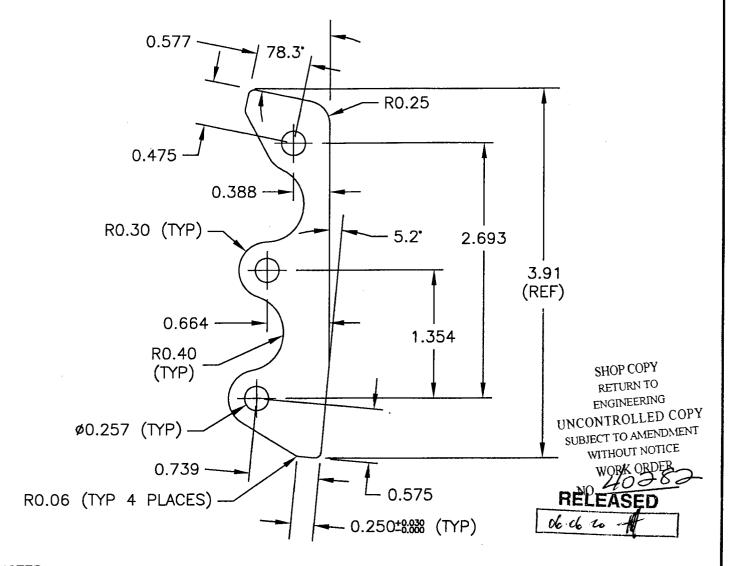
	X	First Artic	:le	_ Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.757	1		VIIN	
3.91	+/-0.030	0.391	V		VerN	
1.354	+/-0.010	1.358	V		Vers	
2.693	+/-0.010	2.702	1		VAN+HO	<u> </u>
0.250	+/-0.010	0.250	$\sqrt{}$		Vern	
R0.25	+/-0.030	RO.25	/		R.G	

Measured by:	mlm	Audited by:		Prototype Approval:	N/A
Date:		Date:	080715	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.06.05	New Issue	KJ/JLM ,	1
В	06.06.23	Dwg Rev. changed	KJ/JLM	



DESIG	, 14	DRAWN BY	DART AEROSPACE L PORT HADLOCK, WA	JSA, INC.
CHEC		APPROVED	DRAWING NO.	REV. B
	PH	1	D2935	SHEET 1 OF 1
DATE			TITLE	SCALE
06.0	5.29		SADDLE SPACER	1:1
Α		99.11.02	NEW ISSUE	
В		06.05.29	ADD 6061-T6 MATERIAL	



NOTES:

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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